

Date: Friday, 5/25/2007 8:15:51 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ANGLE		
Job Number	: 32570		Part Number	: D21751		
Estimate Number	: 10196		Drawing Number	: D2175 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/25/2007	S.O. No. : <i>N/A</i>	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 6/20/2007		
Previous Run	: 31690		Qty:	20	Um:	Each
Written By	:					
Checked & Approved By	:		<i>jl 07.05.28</i>			
Comment	: Est E 04.06.09 Reformat KJ/RF Est Rev:F 06-04-28 Manufactured on Water Jet JLM Est Rev:G As per Rev E 06-11-22 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit	Total : 9.9162 sf(s)
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Material: 2024-T3 (QQ-A-250/4) 0.063" thick	(M2024T3S.063)
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Batch: <i>M104676</i>
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<i>ml 07.06.12</i>
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20
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2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
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1-Cut as per Dwg D2175
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Dwg Rev: <i>5</i>
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Prog Rev: <i>5</i>
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<i>ml 07.06.12</i>
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20
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2-Deburr if necessary
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3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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20
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE
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4.0	QC8	SECOND CHECK
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20
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Comment: SECOND CHECK
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<i>En 07/06/12</i>	<i>x 20</i>
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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20
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Comment: SMALL & MEDIUM FAB RESOURCE 1
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Deburr Stack
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<i>ml 07/06/12</i>	<i>21</i>	<i>20</i>
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/09/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B [REDACTED]	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:15:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 32570

Part Number: D21751

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 07/09/24

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

IN 07/09/24 (20)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 07-09-24 (20)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

EP 07/09/25 (20)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51177

EP 07/09/25 (20)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/09/25

Job Completion



U 07/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32510
Description: Angle	Part Number:	D2175-1/-2
Inspection Dwg: D2175	Rev: E	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	ml. ml
Date:	07 06 12

Audited by:	En
Date:	02/06/18

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

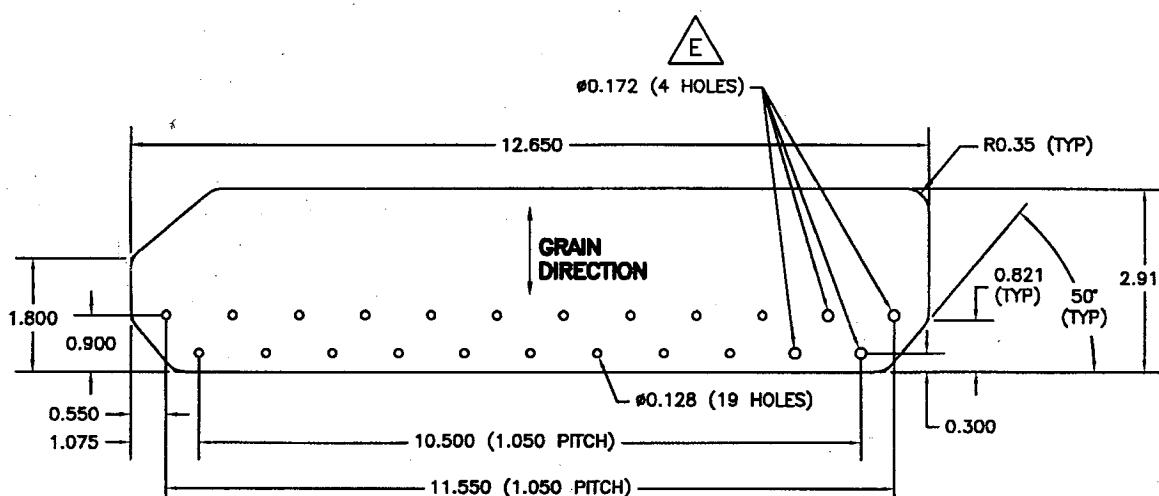
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

086

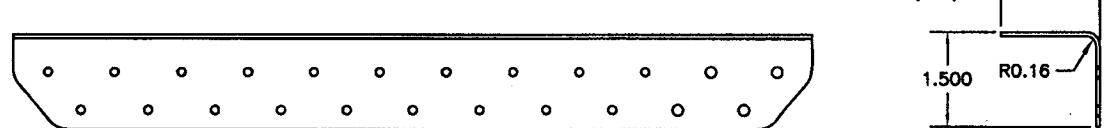
**DART**

**RELEASED**  
06.10.13

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
<i>PH</i>	<i>PH</i>	D2175	SHEET 1 OF 1
DATE		TITLE	SCALE
06.09.25		ANGLE	1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	CHANGED DIMENSION	
C	00.09.11	UPDATE FINISH SPEC	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC HOLE DIA TO $\phi$ 0.172, 4 HOLES	



**D2175-1F FLAT PATTERN**



**D2175-1 BEND DETAIL SHOWN  
(D2175-2 BENT OPPOSITE)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
NOTES:  
1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) ALL DIMENSIONS ARE IN INCHES

SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. *32510*